

Monday, September 12, 2016 10:30:37 AM

Page 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 150930***150930***

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Item ID: D3572-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Guide
Start Date: 8/31/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>M129399</u> Large Fab	0.00				<u>2</u>	<u>EL</u>	<u>16-12-7</u>	
	Memo	0.18							
	1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572 2- grind weld flush at the end of tube only								
140 *140* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00				<u>②</u>	<u>16.12.07</u>		DAS 9 9-89
Quality Control	Memo	0.00							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>②</u>	<u>16.12.07</u>		DAS 9 9-89
Quality Control	Memo	0.01							

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Work Order ID 150930

Monday, September 12, 2016 10:30:37 AM

150930

Page 3

Item ID: D3572-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Guide

Start Date: 8/31/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/12/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

180

HandFinish

Memo

0.03

Hand Finishing

(x2)**Ø**2.16.12/08
BEB

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

M 134858

Memo

0.02

Powder Coating

START TIME: **11:45**OVEN TEMPERATURE: **320**FINISH TIME: **12:15****2****Ø****16-12-13****333**

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

2

DAS

38**9-89**

DEC 14 2016

DQA: _____ Date: _____



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OTHER : _____																					

150930

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 8/31/2016 **Start Qty:** 2.00 ***2***

Required Date: 9/12/2016 **Req'd Qty:** 2.00 ***~***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

210

Identify as per dwg & Stock Location: 5/230

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.03

Quality Control

2 DEC 15 2016 DAS
6
9-89

 DAS DEC 15 2016
21
9-89

DAS
21
9-99

DQA: _____ Date: _____



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Picklist Print

Monday, September 12, 2016 10:30:41 AM

Page 1

Work Order ID: 150930

150930

Parent Item: D3572-041

D3572-041

Parent Item Name: Guide

Start Date: 8/31/2016

Required Date: 9/12/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B revB dwg EC
IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W.188		Purchased	No			110	f	142.2216	2.34	4.926316			
M6061T6T1 000W 188										**		FF 07-12-16	
6061T6 RD TUBE 1.00 X .188W													

Location	Loc Qty	Loc Code
GA002	142.221637	
m126686	138.721657	
m128248	3.49998	

D3572-3

Manufactured No

D3572-3

Guide

130 Each 45.0000 4 8

**

ER 16-12-7

Location	Loc Qty	Loc Code
WA001	15	
145594	15	
WA002	30	
147306	30	

D3572-5

Manufactured No

D3572-5

Bracket

130 Each 24.0000 1 2

**

ER 16-12-7

Location	Loc Qty	Loc Code
WA001	20	
145657	20	
WA002	4	
147497	4	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																											
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